Quality Control

Work Order ID 75620 October-27-11 8:36:45 AM				*756	320*						Page 1
Item ID: Revision ID: Item Name:	D3349-3 Spacer Bushir	_		Accept	*N900		100)*	Setup Star Stop	171.	S1* S2*
Start Date: Required Date: Reference:	27/10/2011 10/11/2011	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item E						
Approvals:		in: M.L.J	Date: 11/10/23	Tooling: SPC (Y/N):		ate:		Ţ.	Run Star Stoj		२1* २ 2 *
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr									
D3349	Rev	A			-						:
*100 *100* Hardinge Hardinge CNC Lath	e Sm al l	Hardinge CNC LATHE : Memo Turn as per	SMALL Folio FA507 and Dwg D334	0.00 0.00 9			·	20	0	of.	St ululi7
*110 *110*		QC2- Inspect parts off m	achine FAI/FAIB	0.00				20	0	of	If 11/11/17
QC Quality Control		Memo		0.00							<u> </u>
120		QC8- Inspect parts - seco	and check	0.00					/		e.
120 QC		Memo		0.00	27	11415	Ś	20)	\$_		

Dail Aciospace Elu	Dart	Aeros	pace	Ltd
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W/O:			10/0	RK ORDER CHANG	EC					······································
DATE	STEP	PRO	OCEDURE CHA		В	v	Date	Qty	Approval Chief Eng /	Approval
								•	Prod Mgr	QC Inspector
Part No	:	PAR #:	Fault Cated	orv:	NCR: \	∕es N	lo DQ	٠ 4:	Date:	
		esolution:								
									Date	
NCR:			WORK ORDI	ER NON-CONFORM	ANCE (I	(CH)				
DATE	STEP	Description of NC			rection B N Sign & Verification Approval Section C Chief Fine					Approval
DATE	SIEP	Section A	Initial Action Descript Chief Eng Chief Eng			gn & Date	Section C		Chief Eng	QC Inspector
	,									
	1	†			I		I			

Work Order ID 75620 October-27-11 8:36:45 AM				*756	320*			Page 2
Item ID: Revision ID: Item Name:	D3349-3 Spacer Bushin	ng		Accept	*N90004	IN1NN*	Setup Star	111.7
	27/10/2011	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item ID: Customer:			14.32
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):	Date: Date:		Run Star Stop	"NRT"
Sequence ID/ Work Center II 130 *130* Small Fab Small Fab)	Operation Description Small Fab Memo Deburr		Set Up/ Run Hours 0.00	Tool ID Too	Ol# Plan Acce Code Qty	pt Reject Qty	Reject Insp. Number Stamp
140 *140 * QC Quality Control		QC5- Inspect part comple	eteness to step on W/O	0.00 0.00 E	((. (1.18	78	_ L	
150 *150* Packaging		Identify as per dwg & Sto	ck Location: WA	0.00	pl 11.11.21	201		?

*****STOCK IN BASKET CELL*****

Packaging

Dart	Aeros	pace	Ltd
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W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:	· •	PAR #:	Fault Categ	jory:	_ NCR: Yes	No DQ	A:	Date:	
	Res	olution:	Disposition	l:	_ QA: N/C (Closed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Action Description	Sign	& Verific		Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng	Date	8			
		and a state of the							
							,		

Work Order ID 75620 October-27-11 8:36:45 AM			*75620*							Page 3		
Item ID: Revision ID: Item Name:	D3349-3 Spacer Bushin	g		Accept	*N900	040	100)*	•	start Stop		S1* S2*
Start Date: Required Date: Reference:	27/10/2011 10/11/2011	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item 1 Customer:	ID:					, • •	• • • •
Approvals:	Process Pla	n:	Date:	Tooling:	D:	ate:]		tart	*N	R1*
	QC:		Date:	_ SPC (Y/N):	D	ate:			S	Stop	*N	R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty		Reject Tumber	Insp. Stamp
*160 *160* QC Quality Control		QC21- Final Inspection - Memo	Work Order Release	0.00						_11	/11	<u>/21</u> %

P(1/30)

Dart Aerospa	ace Ltd
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W/O:	•		WO	RK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHAI	IGE		Ву	Date	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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								: :		
Part No	•	PAR #:	Fault Categ	jory:	NCR	: Yes	No DQ	A:	Date:	
		esolution:								
NCR:			WORK ORDE	R NON-CONFORM	ANCE	(NCR)			
DATE	OTED	Description of NC			tion B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
		A								
		·								
										_

Picklist Print

October-27-11 8:36:50 AM

Work Order ID: 75620

75620

Parent Item:

D3349-3

D3349-3

Parent Item Name:

Spacer Bushing

Start Date: 27/10/2011

Required Date: 10/11/2011

Page 1

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP A05.02.09New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1018R0.375		Purchased	No			100	f	8.6000	0.1333	2.806316	5		
M1018R0	n 375								**	3.025	. (So	24/11/19

1010-1025 round bar .375

Location Loc Oty Loc Code MAT038 8.6 3.025' 110860 8.6

Dar	t /	۹e	ros	sp	ac	e l	Lto	t
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		WC	ORK ORDER CHANGE	ES				
STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mar	Approval QC Inspector
· ·	DAD #:	Fault Cata		NCD: Vos	No DO	A .	Data	<u> </u>
							Date	
	· · · · · · · · · · · · · · · · · · ·	WORK ORD	ER NON-CONFORMA	NCE (NC	R)			
CTED	Description of NC	Corrective Action			Verific	ation	Approval	Approval
SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		& Secti		Chief Eng	QC Inspector
		:PAR #: Resolution: STEP Description of NC Section A	STEP PAR #: Fault Cate Resolution: Disposition WORK ORD STEP Description of NC Section A Initial Chief Eng	STEP PAR #: Fault Category: Resolution: Disposition: WORK ORDER NON-CONFORMA STEP Description of NC Section A Corrective Action Section Chief Eng Action Description Chief Eng	:PAR #: Fault Category: NCR: Yes Resolution: Disposition: QA: N/C C WORK ORDER NON-CONFORMANCE (NC STEP Description of NC	STEP PAR #: Fault Category: NCR: Yes No DQ. Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	STEP PAR #: Fault Category: NCR: Yes No DQA: Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	STEP PAR #: Fault Category: NCR: Yes No DQA: Date: _ Resolution: Disposition: QA: N/C Closed: Date: _ WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A

DART AEROSPACE LTD	Work Order:	75620		
Description: Spacer Bushing	Part Number:	D3349-3		
Inspection Dwg: D3349 Rev: A		Page 1 of 1		

FIRST ARTICLE INSPECTION CHECKLIST

	FIRS	T ARTICLE IN	ISPECTI	ON CHE	CKLIST		
	,	First Arti	cle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Com	ıments
1.500	+/-0.010	1.4985	1		5408		
Ø0.375	+/- 0.010	60.375			11		
Ø0.257	+/-0.010 +/- 0.010 +0.005/-0.000	\$0.2575	V		N		
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4-1-1-1							
							
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	21		<u> </u>]	
Measured by:	AS/m	Audited by:	77		Prototype	Approval:	N/A
Date:	11/11/17	Date:	11/1	1/1		Date:	N/A
Rev Date	Change	- L	····/			evised by	Approved
A 05.04.26	New Issue			-		J/JLM A	

Dart	Aeros	pace	Ltd
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W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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			17.17.000				•		
							•		
							;		
Part No	•	PAR #:	Fault Cate	egory:	NCR: Yes	No DQA:		Date: _	
	Re	esolution:	Disposition	on:	QA: N/C Clo	sed:		Date: _	
NCR:			WORK ORD	DER NON-CONFORMA	ANCE (NCR)			2	
		Description of NC			ion B	Verifica	tion	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
		,							
	,								



DESIGN PH	DRAWN BY	DART AEROSP HAWKESBURY, ONTAR	
CHECKED	APPROYED	DRAWING NO. D3349	REV. A SHEET 1 OF 1
DATE		TITLE	SCALE
04.11.11		SPACER BUSHING	1:1
Α	04.11.11	NEW ISSUE	

1.750	Ø0.375 Ø0.257
<u>D3349-1</u>	
	Ø0.375
1.500	SHOPCOLL PRETURNED \$0.257
<u>D3349-3</u>	ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 75620 M.C. J
	11/10/27

D3349-1/-3 SPACER BUSHING

Ø0.375 AISI1018-1025 ROUND BAR (REF DART SPEC. M1018-R0.375) 1) MATERIAL:

2) FINISH: NONE

3) BREAK ALL SHARP EDGES 0.005 TO 0.010

4) ALL DIMENSIONS ARE IN INCHES

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
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								. (·
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:	I	Date:	
	Reso	olution:	Disposition	1:	QA: N/C CI	osed:		Date: _	
NCR:				ER NON-CONFORMA	NCE (NCR	R)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	on B Sign & Date	Verificat Section		Approval Chief Eng	Approval QC Inspector
							-		
								,	